

Date: Tuesday, 11/29/2005 7:42:33 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 25068	
Estimate Number : 11107	
P.O. Number :	Part Number : D34071
This Issue : 11/29/2005 S.O. No. :	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 11/29/2005 Type : MACHINED PARTS	Drawing Revision : C
Previous Run :	Material :
Written By : <u>POIA New Issue by R.C</u>	Due Date : 12/18/2005 Qty: 10 Um: Each
Checked & Approved By : <u>05/10/18</u>	
Comment : Created By Auto Work Order	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R0750	Inventory
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Comment: Qty.: 0.3843 f(s)/Unit Total: 3.8430 f(s)
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)
 Identify for D3407-3
 Batch: M18742

ml 05/12/01 10

Tools:

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA596 Rev: A & Dwg D3407 Rev: C

2-Deburr

ml 05/12/01 10

Tools:

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407





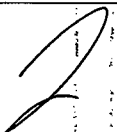
2-Deburr

ml 05/12/01 10

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/01	2	1 piece scrap the offset was wrong		Scrap, destroy & replace Adjust program.	 05/12/01	 05-12-01		 05-12-01

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 25068

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

MS 05/12/06 10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Tools:

MS 05/12/06 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

MS 05/12/06 10

Tools:

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

MS 05/12/07 (10)

MS 05/12/08 (10)

Tools:

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25068
Description: Stem		Part Number: D3407+1
Inspection Dwg: D3407 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	± 0.10	5.270	—			
4.250	± 0.00 ± 0.10	4.242	—			
3.250	± 0.16	3.253	—			
0.500	± 0.10	0.498	—			
0.470	± 0.16	0.470	—			
0.063	± 0.16	0.069	—			
0.550	± 0.10	0.550	✓			
0.500	± 0.16	0.502	—			
0.750	± 0.10	0.750	✓			
0.625	± 0.10	0.628	—			
0.625	± 0.10	0.623	—			
0.363	± 0.16	0.362	—			
0.150	± 0.10	.155	✓			
0.250	± 0.10 ± 0.00	.252	—			
0.625	± 0.16	.628	✓			
1/4-28	0.243-0.249	0.2455	—			
10W	0.261-0.267	0.264	✓			

Measured by: <i>ml</i>	Audited by: <i>er</i>	Prototype Approval:
Date: 05/12/01	Date: 05/12/01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	